ABSTRACT OF THE DISCLOSURE

A dome of a domed aerosol can end is initially formed and then a crown of the can end is formed so that material flow within a workpiece from which the can end is formed is controlled to substantially eliminate wrinkling problems associated with the use of sheet material which is thinner than conventionally used, for example double reduced steel. The peripheral portion of the workpiece is initially clamped between a blank punch and a draw pad, and also between a knockout and a crown ring. An outer first portion of the dome is then formed by an outer redraw sleeve and a dome form die. An inner second portion of the dome is next formed by a dome punch and the dome form die. There may be limited contact of the dome punch with the workpiece during formation of the first portion of the dome and the workpiece may also be clamped between the outer redraw sleeve and the dome form die during formation of the second dome portion. Controlled clamping between the blank punch and the draw pad, between the knockout and the crown ring and between the outer redraw sleeve and the dome form die control material flow for improved formation of the domed aerosol can end with effective elimination of radial wrinkles associated with prior art forming methods and apparatus.